

Work Order ID 86025

June-19-12 4:05:23 PM

86025

Page 1

Item ID: D4148-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Assembly, Fwd **7x**

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: **MLJ**

Date: **12/06/20** Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	D								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: SI 468	0.00							
120									
Packaging	Memo	0.00							
Packaging									

7x

12/07/23

8.26.103

(47)

7x

12-7-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86025***86025***

Page 2

June-19-12 4:05:23 PM

Item ID: D4148-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/7/5 JF

MF

12-07-04

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Picklist Print

June-19-12 4:05:26 PM

Page 1

Work Order ID: 86025

86025

Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

IPP Rev:C

10.10.29 as per revC DD verf:EC

IPP REV:D 11.03.02

AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21043-3

Purchased

No

100

Each

1,319.000

4

8

**

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1247

118077

2

118614

51

118686

30

119758

20

121255

188

121708

956

14

MS21043-4

Purchased

No

100

Each

1,094.000

1

12

**

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1054

119546

115

121162

439

121652

500

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 86025

86025

Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D2690-6 Manufactured No

D2690-6

Lanyard Assembly

100 Each 6.0000 1 4

**

Location

Loc Qty

Loc Code

ST014

6

83360

6

D3910-1 Manufactured No

D3910-1

Crosstube Lug

100 Each 31.0000 1 4

**

Location

Loc Qty

Loc Code

st507

31

81474

2

81573

29

D4091-1 Manufactured No

D4091-1

Mounting Lug

100 Each 66.0000 1 4

**

Location

Loc Qty

Loc Code

ST458

66

81168

26

81575

40

D4148-1 Manufactured No

D4148-1

Crosstube Lug Plate, Fwd

100 Each 30.0000 2 8

**

Location

Loc Qty

Loc Code

ST101

30

83421

10

85753

20

EP 12/07/03
385757
3
4

EP 12/07/03

7

EP 12/07/03

7

EP 12/07/03

10
4

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 3

Work Order ID: 86025

86025

Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00



D4148-3

Manufactured No

100

Each

2.0000

1

4

D4148-3

Stud Receiver, Lower

**

EP 12/07/03

385754 (52)

2

EP 12/07/03

D4148-5

Manufactured No

100

Each

7.0000

1

4

D4148-5

Eyebolt Stud

**

Location

Loc Qty

Loc Code

ST101

2

83356

2

Location

Loc Qty

Loc Code

ST102

7

84196

7

7

AN3C12A

Purchased No

100

Each

225.0000

2

8

AN3C12A

Bolts

**

EP 12/07/03

14

Location

Loc Qty

Loc Code

GA

38

120449

38

ST351

187

117514

4

118112

5

118451

22

119510

1

120423

51

121259

4

121584

50

121689

50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

June-19-12 4:05:27 PM

Page 4

Work Order ID: 86025

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

86025

D4148-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C13A Purchased

No

100

Each

44.0000

3

12

AN4C13A

BOLT

**

Location

Loc Qty

Loc Code

ST357

44

120187

1

121827

43

MS17984-C413

Purchased

No

100

Each

17.0000

1

4

MS17984-C413

PIN, QUICK RELEASE

**

Location

Loc Qty

Loc Code

ST315

3

114340

1

118612

2

ST333

14

121350

14

MS20615-4M18

Purchased

No

100

Each

33.0000

8

32

MS20615-4M18

Rivet

**

Location

Loc Qty

Loc Code

322

3

121349

3

ST322

30

121444

30

NAS1149C0332R

Purchased

No

100

Each

9,782.000

4

16

NAS1149C0332R

Washer

**

Location

Loc Qty

Loc Code

297

9782

122063

9782

EP 12/07/03

M 122141 (21x)
EP 12/07/03

7
EP 12/07/03

M 122141
(56x)

EP 12/07/03

28

June-19-12 4:05:27 PM

Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

June-19-12 4:05:27 PM

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Work Order ID: 86025

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

86025

D4148-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

100

Each

3,718.000

6

24

NAS1149C0432R

Washer

**

CP 12/07/03

Location

Loc Qty

Loc Code

ST297

1070

117291

70

119124

1000

ST298

2648

121255

2648

42

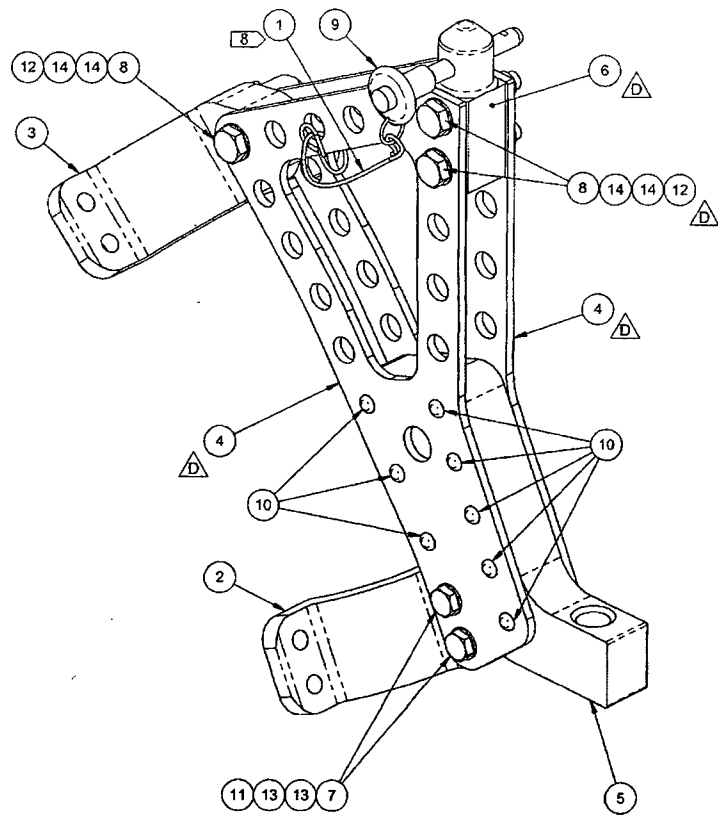
Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.67 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86025 MJS
12/06/20

ITEM	QTY	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

RELEASED
2011-02-24

D	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.260" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. D
SHEET 1 OF 5
TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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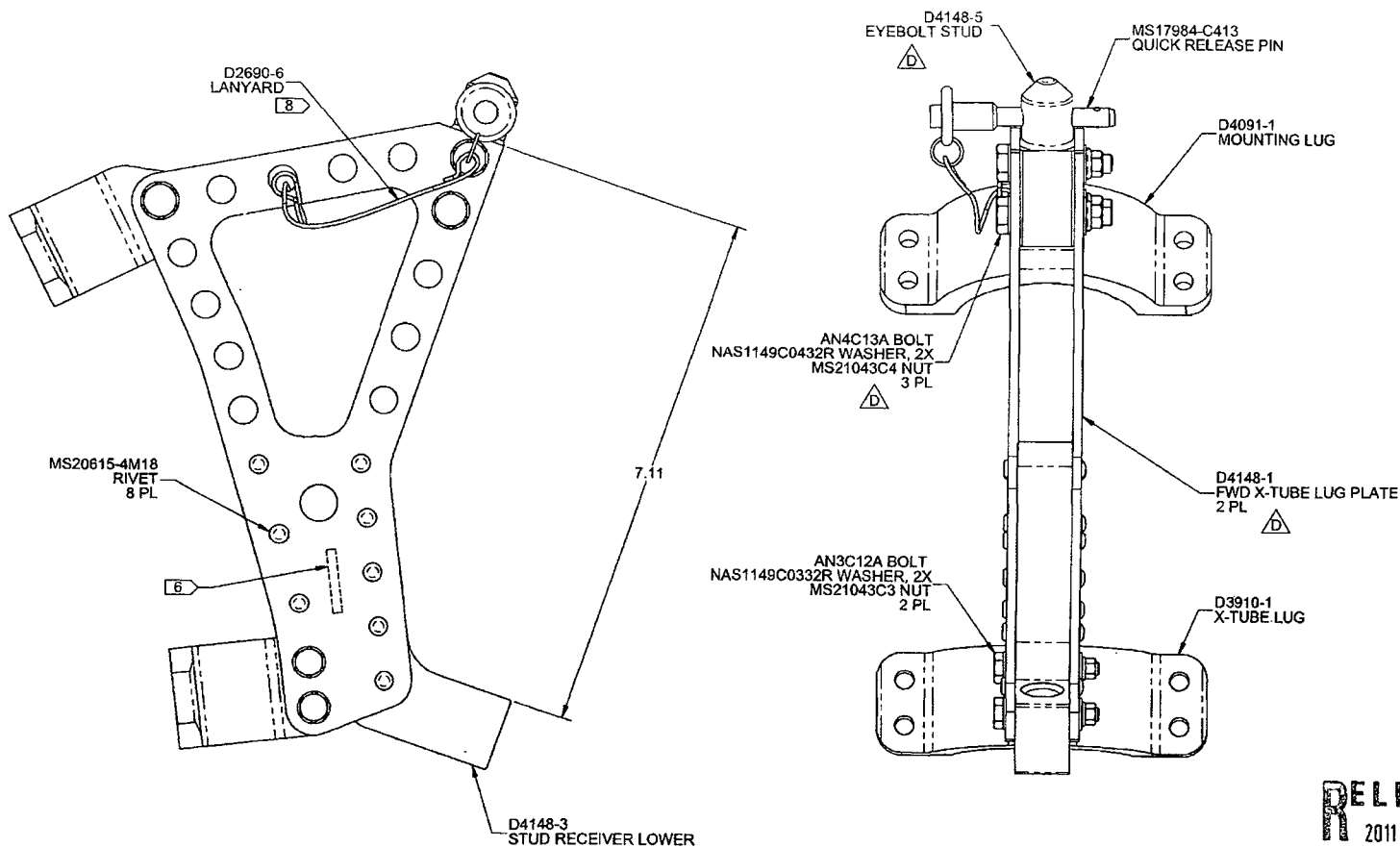
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

RELEASED
2011-02-24
JMP

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

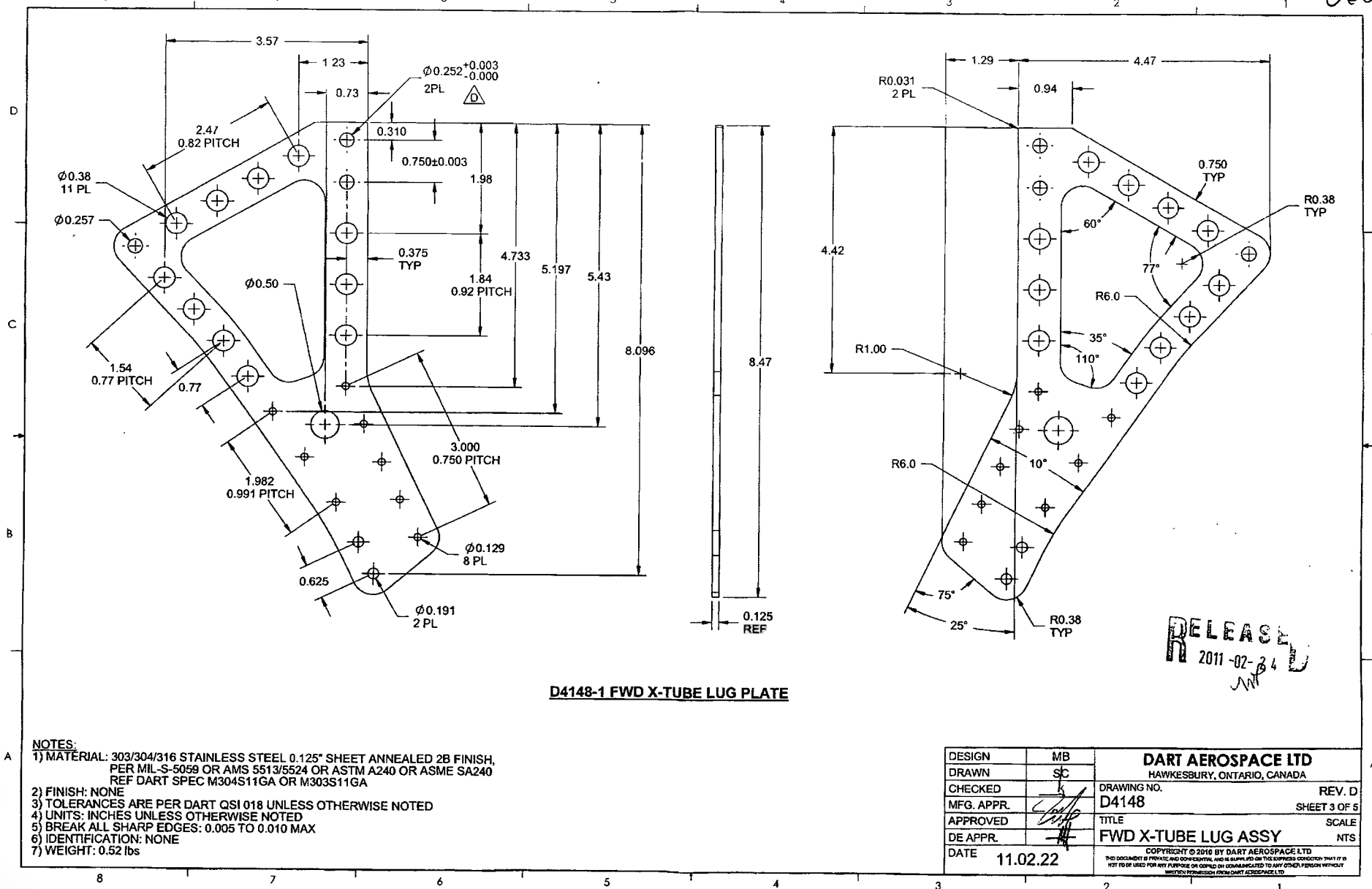
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

86028



D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4148	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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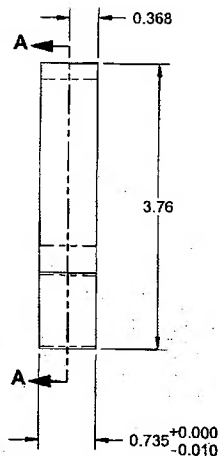
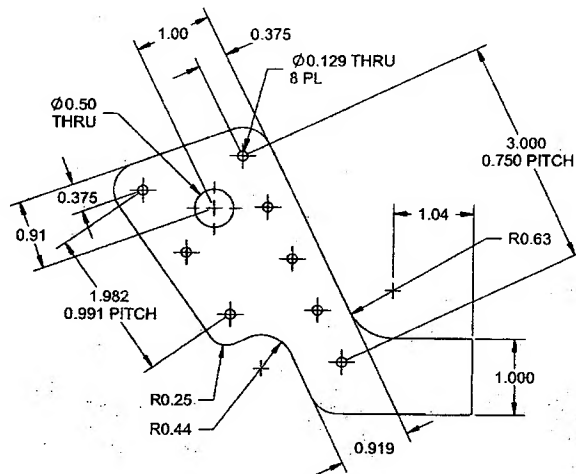
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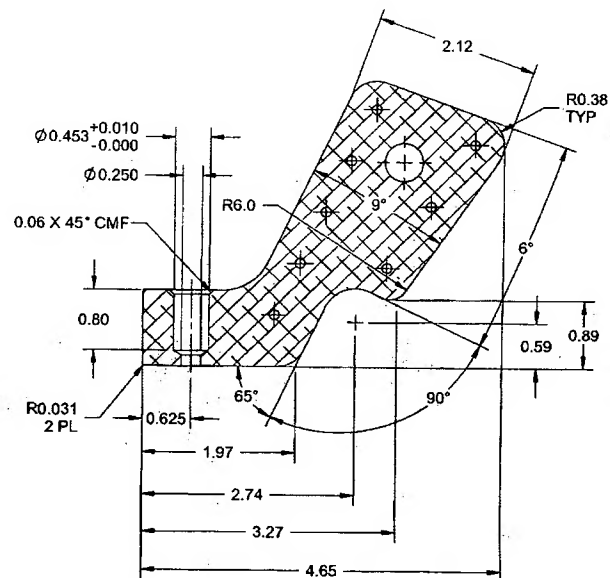
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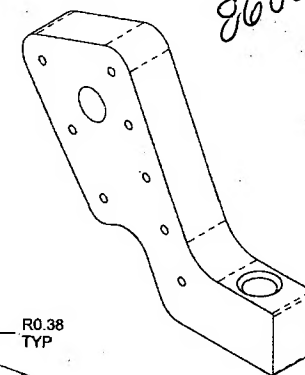
NOTE: Date & initial all entries



D4148-3 STUD RECEIVER LOWER



SECTION A-A



NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 4 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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2011-02-24

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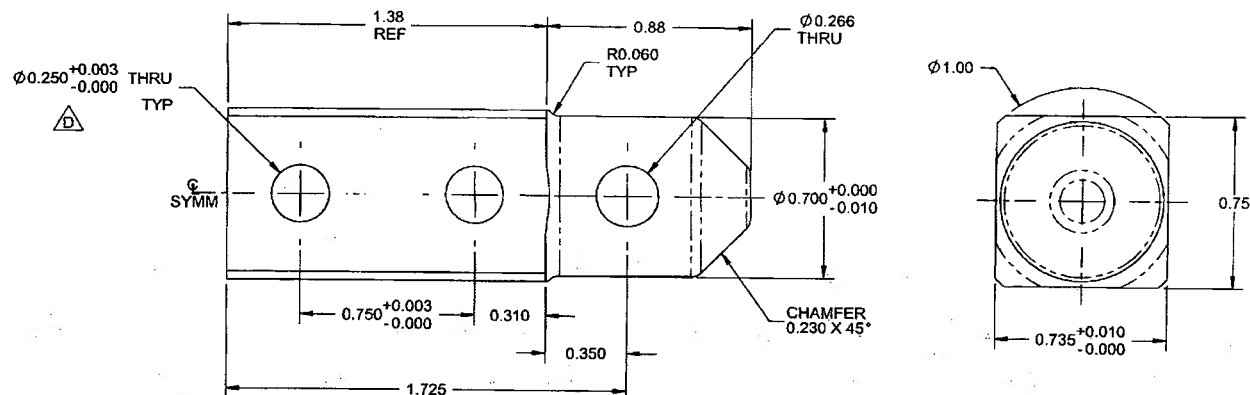
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NOTE: Date & initial all entries

86025



D4148-5 EYEBOLT STUD

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. D4148	REV. D
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		FWD X-TUBE LUG ASSY	SCALE
DE APPR.			NTS
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries